

## Section 804—Abrasives for Blast Cleaning

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### 804.1 General Description

This section includes the requirements for abrasives used in blast cleaning.

#### 804.1.01 Related References

##### A. Standard Specifications

General Provisions 101 through 150.

##### B. Referenced Documents

TCLP-EPA SWD 846-1311

AASHTO T 27 Aggregate Gradation

[QPL 68](#)

### 804.2 Materials

#### 804.2.01 Abrasives

##### A. Requirements

###### 1. Types

Make the abrasives of low dusting mineral with a minimum of 10 percent by weight G-80 steel grit added, and blended homogeneously throughout the abrasive.

Use a mineral abrasive listed on [QPL 68](#).

If you propose to use an alternative abrasive mixture, submit it to the Office of Materials and Research for approval before use.

###### 2. Detrimental Substances

Use abrasives that contain less than 100 ppm of any corrosive compound such as sulfate, chloride, or any EPA characteristic compound such as lead, chromium, or arsenic that can be detected by the EPA Toxicity Characteristic Leaching Procedure (TCLP).

###### 3. Grades

Ensure that the mineral abrasive used to blend with steel grit meets the grade for the sizes in the following table (Size A fits coal and copper slag; Size B fits staurolite abrasive)

Fractional Percent by Weight Retained on Each Sieve, by Sieve Size								
Size	No. 16 (1.18 mm)	No. 20 (850 µm)	No. 30 (600 µm)	No. 40 (425 µm)	No. 50 (300 µm)	No. 60 (250 µm)	No. 100 (150 µm)	PAN
A	0-10	5-35	25-50	20-45	5-35	0-10		0-10
B	0-2	0-2	0-2	0-5	5-25	5-25	30-60	0-20

###### 4. Packaging

a. Furnish abrasives for blasting in moisture-proof and mildew-resistant bags.

Plainly show the size designation, requisition number, and purchase order number on the bags or on tags firmly affixed to each bag.

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### B. Fabrication

General Provisions 101 through 150.

### C. Acceptance

The Department will take representative samples of the material sent to the Department, and test as follows:

Test	Method
Aggregate gradation	AASHTO T 27
Toxicity Characteristic Leaching Procedure (TCLP)	TCLP-EPA SWD 846-1311

### D. Materials Warranty

General Provisions 101 through 150.